

Date: Wednesday, 2/20/2008 4:16:17 PM
 User: Kim Johnston

Process Sheet

10

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BASKET BASE ASSEMBLY (350)	
Job Number	37511C		Part Number	D2221 <i>pd 03.02.21</i>	
Estimate Number	10189		Drawing Number	D2221 UR, D2235	
P.O. Number	:		Project Number	N/A	
This Issue	2/20/2008	S.O. No. :	Drawing Revision	F/B1	
Prsht Rev.	NC		Material	:	
First Issue	/ /	Type : LARGE FAB ASSY	Due Date	3/7/2008	Qty: 1 Um: Each
Previous Run	37247C				
Written By	:				
Checked & Approved By	:	<i>PS 08 02 21</i>			
Comment	Est Rev: J 05.09.02 Added D3442-1 KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
	Qty Part Number	Description Batch	
	4 D3166-1	RIB <i>m37882</i>	<i>FC 08 04 21</i>
2.0	D22323	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty Part Number	Description Batch	
	2 D2232-3	Hinge bracket <i>B36841e</i>	<i>Pd 08-04-24</i>
3.0	D2325	Support Gusset (350 Bask)	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
	Qty Part Number	Description Batch	
	4 D2325	Support Gusset <i>1936691</i>	<i>Pd 08-04-24</i>
4.0	D23273	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty Part Number	Description Batch	
	2 D2327-3	Bushing <i>B 37851</i>	<i>FC 08-04-21</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET BASE ASSEMBLY (350)

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2581 Mounting Bracket



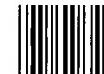
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2581 Mounting Bracket A37248

FC 08 04 24

6.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3442-1 Shim B24421

PD 08 04 24

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)

Pick:

Qty Part Number Description Batch
39.69 sf M304EX0.75-16F Expanded Metal M107511

FC 08 04 24

8.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick: 0.065 PD 08 04 24

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M107514

PD 08 04 24

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

PD 08-04-24

2-Drill hole in D2221-3 as per Dwg D2221

PD 08-04-24

3-Deburr

PD 08-04-24

4-Remove all markings on material before welding

PD 08-04-24

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

PD 08-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 37511C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10/04/25

11.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

10/04/25 (c)

30 min

12.0 POWDER COATING

POWDER COATING



M107550

26/04/2008

S.122 08.01
#1 395.6 F
#2 33751/C F
#3 --- F
#4 02221 F

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-107550 08/04/
08/04/25

13.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 08/04/28

14.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/28 (f)

Job Completion



u 08.04.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



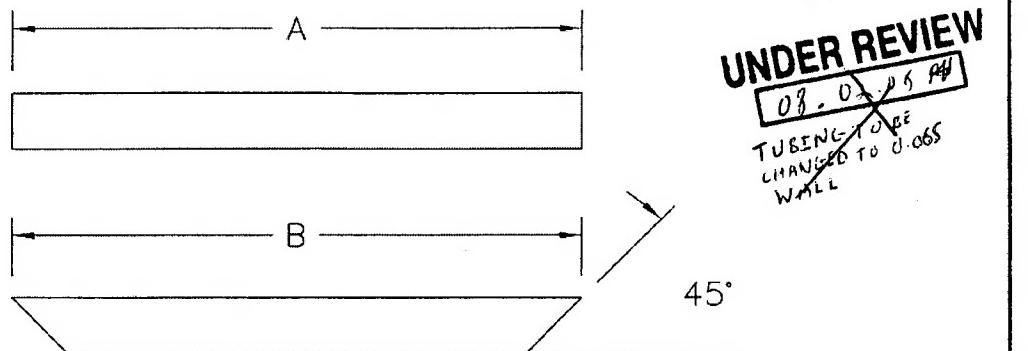
DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
		C 95.11.21 SEPARATE BASKET AND LID	
		D 96.06.21 CHANGE LATCH	
		E 01.04.19 CHANGE HINGE	
		F 05.06.07 ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

RELEASED

05.08.19 *[initials]*

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION	SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE NO. 3751LC
D2221-1	2	—	96.00	RIB	
D2221-3	2	—	25.50	RIB	
D2221-5	2	18.88	—	RIB	
D2221-7	1	55.25	—	RIB	
D2232-3	2	N/A	N/A	HINGE PLATE	
D2235-1	4	N/A	N/A	RIB	
D2325	4	N/A	N/A	SUPPORT GUSSET	
D2327-3	2	N/A	N/A	BUSHING	
D2581	2	N/A	N/A	MTG BRKT	
D3442-1	2	N/A	N/A	SHIM	

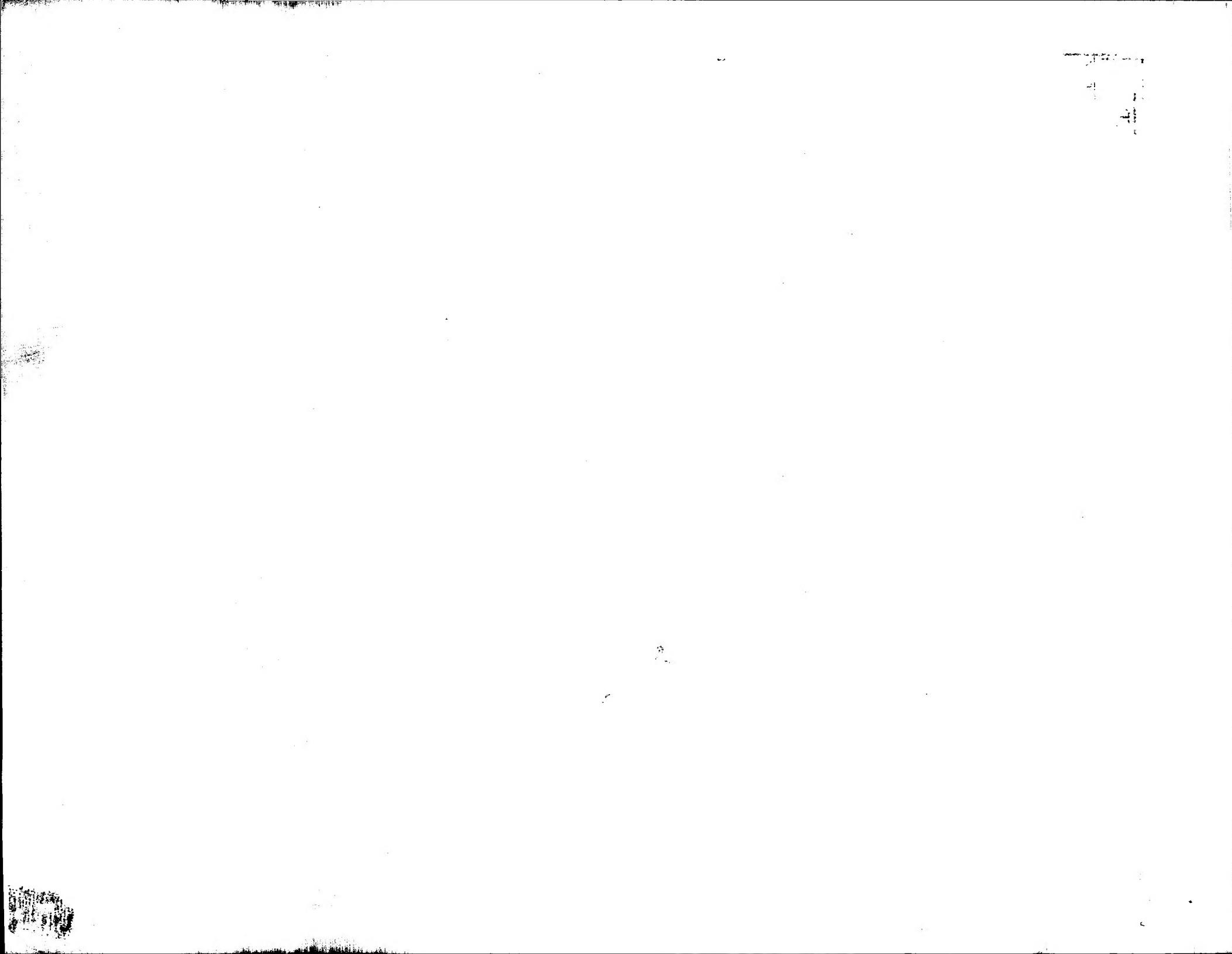


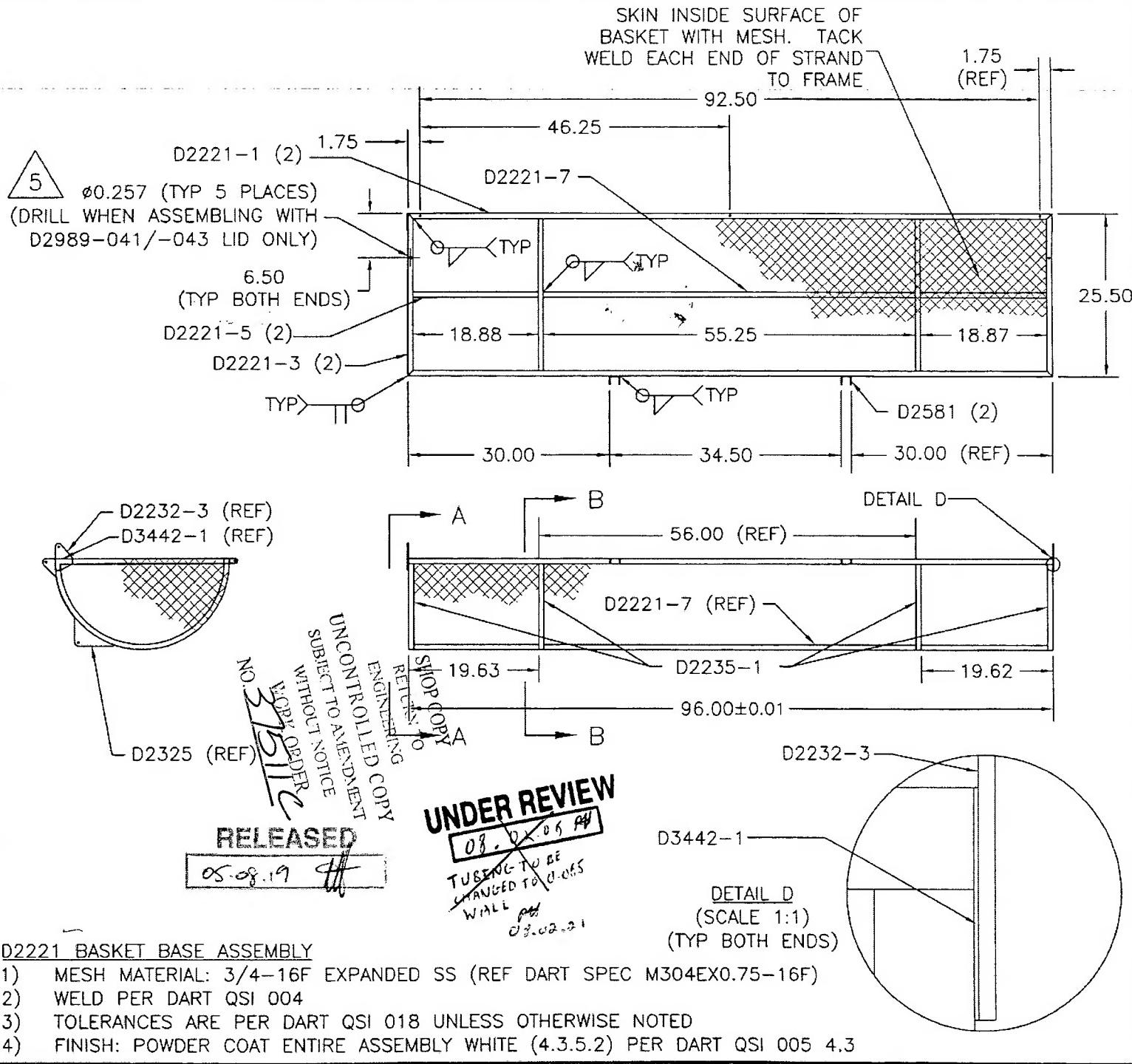
D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060) *0.065 per 0.02-0.031*
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

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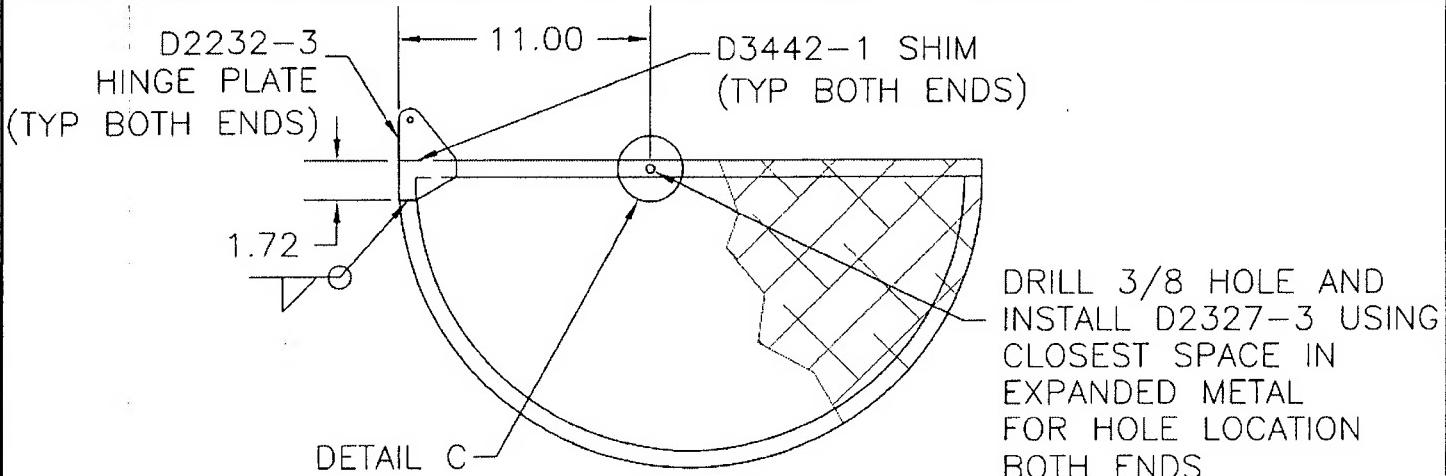


DESIGN BN	DRAWN BY PH	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE		DRAWING NO.
05.06.07	<i>[Signature]</i>	D2221
		TITLE
		BASKET BASE ASSEMBLY (350)
		SHEET 2 OF 3
		SCALE

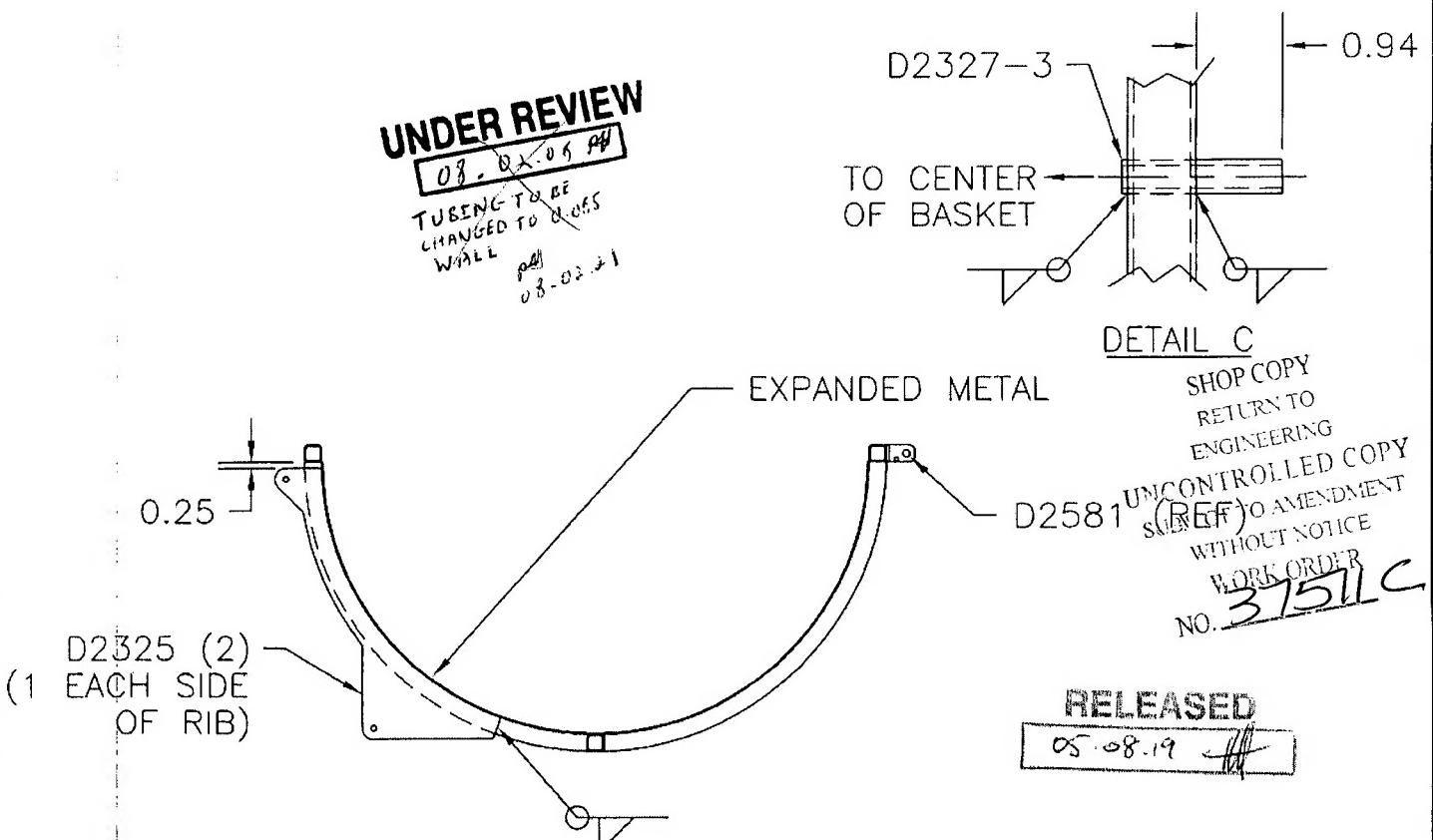
DART



DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8



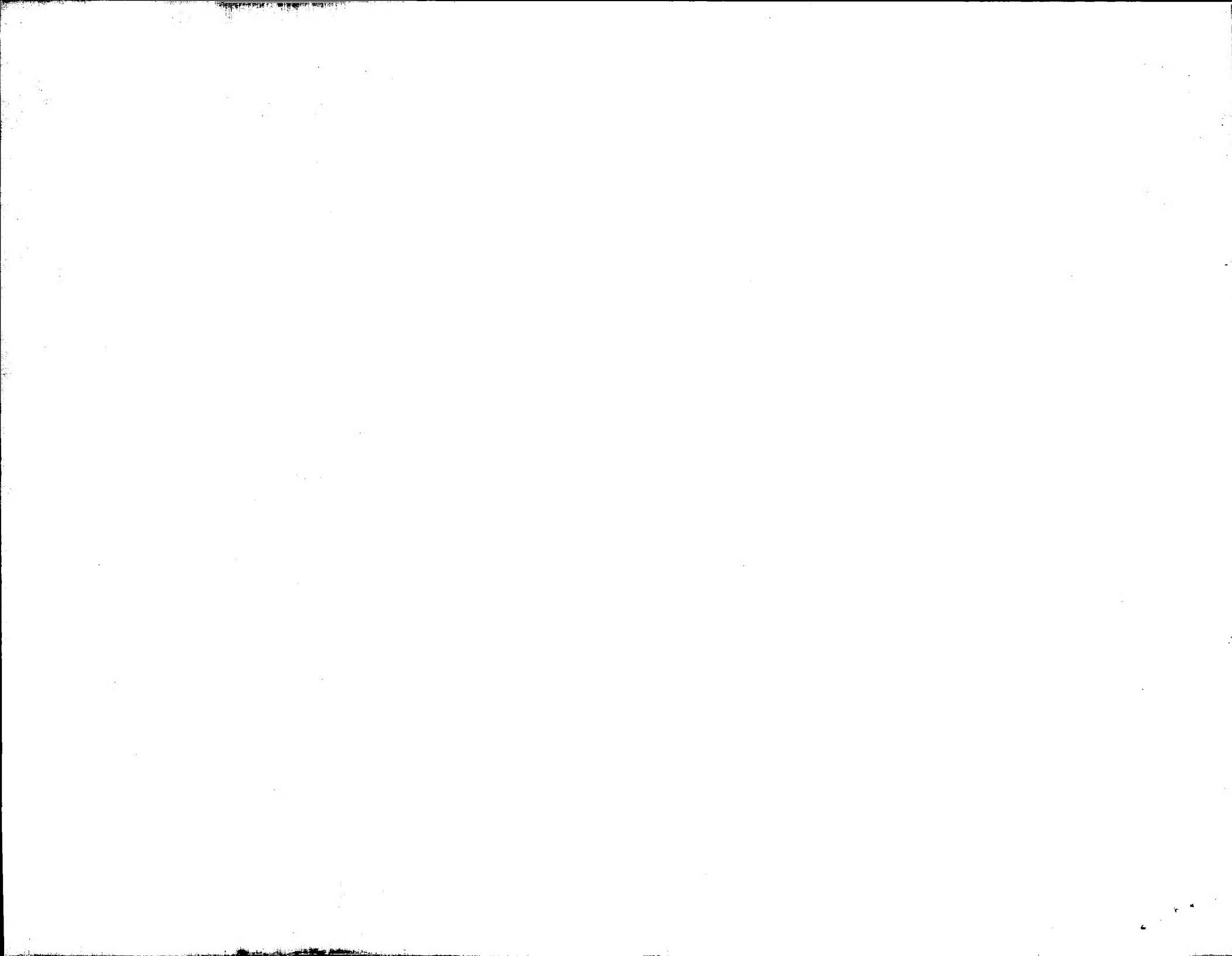
SECTION A-A SAME BOTH END RIBS



SECTION B-B SAME BOTH CENTER RIBS

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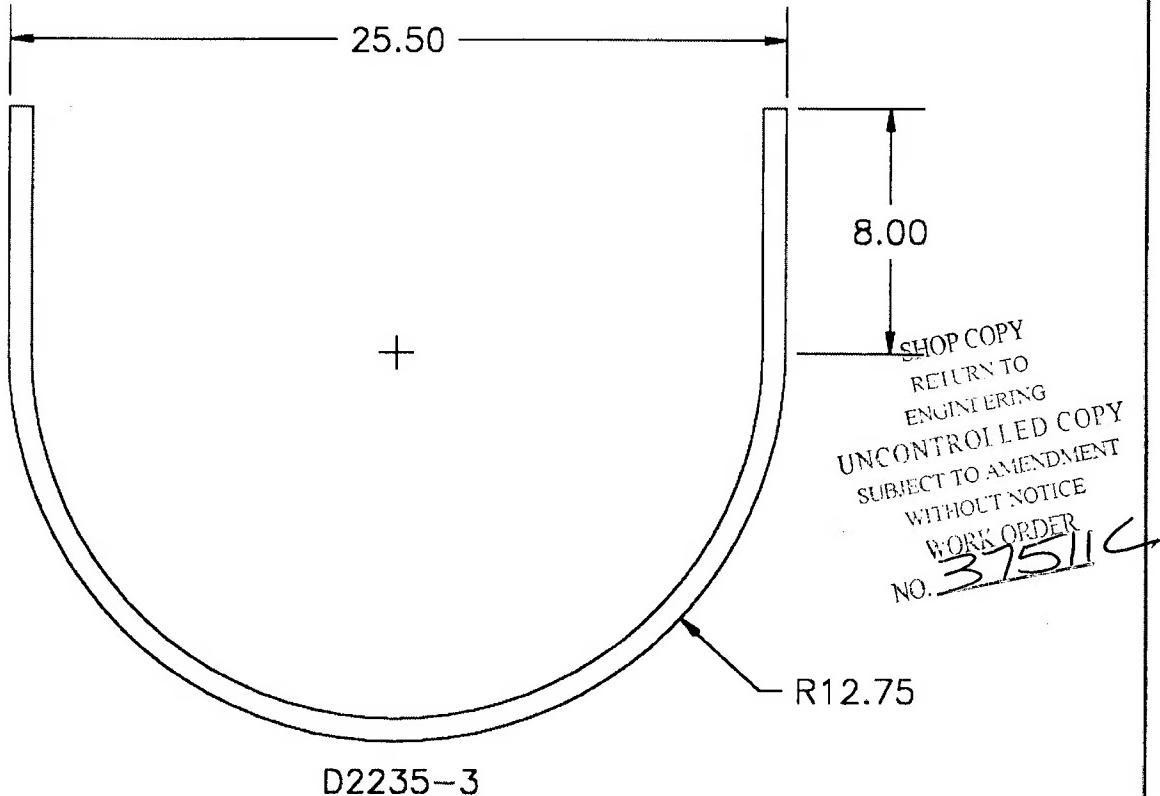
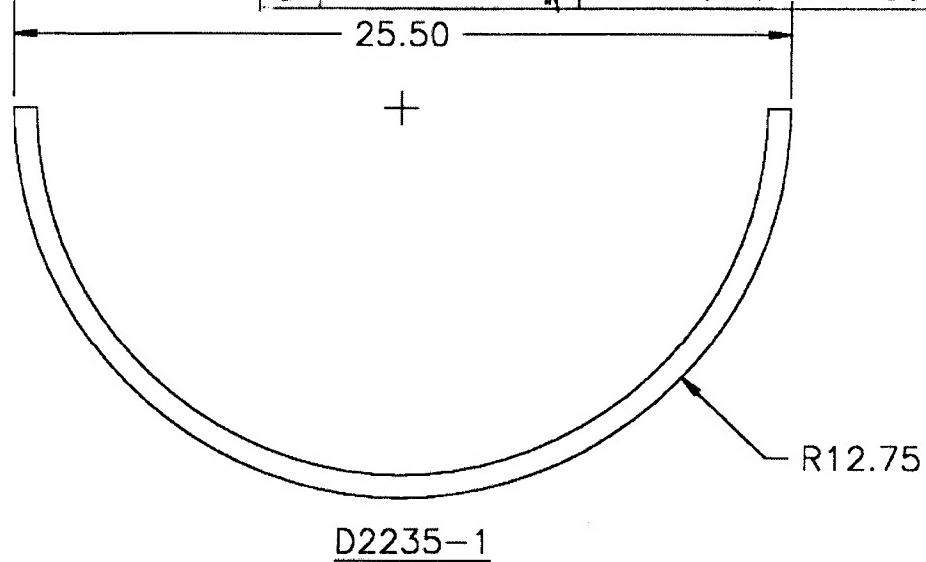
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DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235
DATE 94:12:16		REV. B SHEET 1 OF 1 SCALE

BI 02.03.06 (P) CAN BE MADE FROM D3166-1

RELEASED
R 960507

CAN BE MADE FROM D3166-1 BI
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

